

AMENDMENTS TO THE CLAIMS:

Please replace the claims with the claims provided in the listing below wherein status, amendments, additions and cancellations are indicated.

1. (Currently Amended) Method for grinding a rotationally symmetrical machine part provided with a longitudinal bore, ~~the one the machine part being substantially in a frusto-conical form having a flat annular end-face surface symmetrically formed about said bore, end-face surface of which is embodied as an active surface in the form of a flat truncated cone with a cross-section with a straight contour, characterized in that comprising: grinding first said active end-face surface on said machine part held on one side at its exterior circumference by is ground; positioning the rotating circumferential surface of the first cylindrical grinding wheel being positioned perpendicularly against said active end-face surface, said machine part being displaced in the direction of its rotational and longitudinal axis relative to said first grinding wheel, whereby the axial extension of said first grinding wheel covers the radial angled extension of said active end-face surface[[],]; and~~

~~grinding, in that then in the same clamping, the interior wall of said longitudinal bore is ground; by introducing a second grinding wheel of smaller diameter being introduced into said longitudinal bore of said machine part by~~

pivoting a grinding headstock, which carries at least said first and said second grinding wheel, and placed radially against said interior wall.

2. (Previously Presented) Method in accordance with claim 1, wherein said interior wall of said longitudinal bore is ground using longitudinal grinding.

3. (Previously Presented) Method in accordance with claim 2, wherein said interior wall of said longitudinal bore is ground using peel-grinding.

4. (Previously Presented) Method in accordance with claim 1, wherein said interior wall of said longitudinal bore is ground using infeed grinding.

5. (Previously Presented) Method in accordance with claim 1, wherein individual axial segments of said interior wall of said longitudinal bore are ground.

6. (Previously Presented) Method in accordance with claim 1, wherein at least three grinding wheels are brought into their working position by pivoting three grinding spindles that carry said grinding wheels.

7. (Currently Amended) Apparatus for grinding a rotationally symmetrical machine part provided with a longitudinal bore, the machine part being substantially in a frusto-conical form having a flat annular end-face surface symmetrically formed about said bore one end-face surface of which is embodied as an active surface in the form of a flat truncated cone with a cross-section with a straight contour, comprising[[],] :

a clamping device for one-sided clamping of said machine part at its exterior circumference and for rotationally driving it[[],] ;

a grinding spindle slide that can be moved in a direction running transverse to the rotational and longitudinal axis of said machine part[[],] ;

a device for longitudinal displacement of said machine part in the direction of its rotational and longitudinal axis[[],] ;

a grinding headstock that is attached to said grinding spindle slide via a pivot axis running perpendicular to the displacement plane of said grinding spindle slide and that carries at least two grinding spindles that can be pivoted into the working position[[],] ;

a first cylindrical grinding wheel, arranged on said first grinding spindle and driven thereby, that is for vertical grinding of said active end-face surface situated on said machine part and that has an axial extension that is larger than the radial angled extension of said active end-face surface[[],] ; and

with a second cylindrical grinding wheel, arranged on said second grinding spindle and driven thereby, that has a smaller diameter than said first grinding wheel and that is for interior cylindrical grinding of the longitudinal bore of said machine part,

whereby depending on the pivot position of said grinding headstock either the rotating circumferential surface of said first grinding wheel is placed on said active end-face surface of said machine part to be ground or the axis of said second grinding wheel runs spaced from and parallel to said rotational and longitudinal axis of said machine part.

8. (Previously Presented) Apparatus in accordance with claim 7, wherein in the arrangement of two grinding spindles on said grinding headstock their axes run parallel to one another and said two grinding wheels are attached on the same side of said grinding headstock.

9. (Previously Presented) Apparatus in accordance with claim 8, wherein three grinding spindles, each with a grinding wheel, are attached to said grinding headstock at angle intervals of 120 degrees each.

10. (Previously Presented) Apparatus in accordance with claim 7, wherein said clamping device is a chuck with centrally adjustable clamping jaws.

11. (Previously Presented) Apparatus in accordance with claim 7, wherein said clamping device is located on a grinding table that can be moved in said rotational and longitudinal axis of said machine part relative to said grinding spindle slide.